

# Work Order ID 80749

\*80749\*

Page 1

February-28-12 1:14:19 PM

Item ID: D4277-9 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Rib  
 Start Date: 28/02/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 13/03/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/28 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4277	D								

100		0.00							
*100*									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D4277 2- Remove marking, deburr								
110	QC6- Inspect dimensions to drawing	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: _____	0.00							
*120*									
Packaging	Memo	0.00							
Packaging	***STOCK IN BASKET CELL***								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80749****\*80749\***

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February-28-12 1:14:19 PM

Item ID: D4277-9

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib

Start Date: 28/02/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/5/99

MF 12-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-28-12 1:14:24 PM

Page 1

Work Order ID: 80749

\*80749\*

Parent Item: D4277-9

\*D4277-9\*

Parent Item Name: Rib

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 2.00

Required Qty: 2.00

## Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased		No		100	f	348.2521	1.125	2.368421			

\*M304TS0 500W 049\*

\*\*

SAD

12-05-07

Square Tubing

## Location

## Loc Qty

## Loc Code

MAT034

348.2520653

116610

0.8383

117721

0.3234

117999

2.43919739

118460

344.651168

2.3685

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D4277-1 RIB

D4277-3 RIB

D4277-5 RIB

D4277-7 RIB

D4277-9 RIB

D4277-11 RIB

D4277-19 RIB



STAMP  
DATE  
BY  
NO.

NO 80749 MLJ  
12/02/28

RELEASED  
2011-02-24  
MD

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/15/17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	MD	D4277	SHEET 1 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	RIBS	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

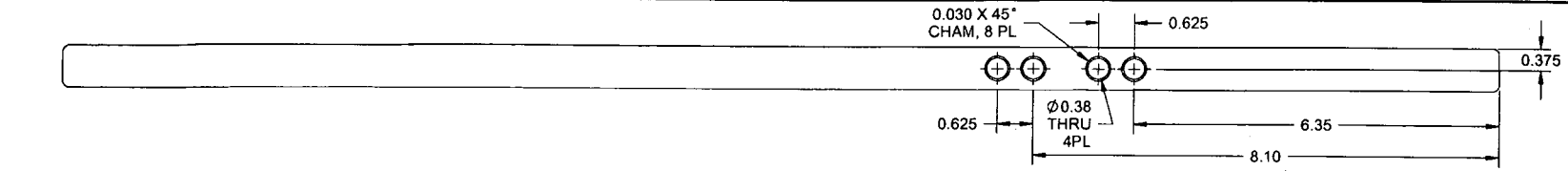
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

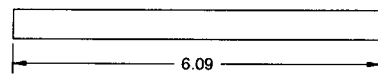
**NOTE:** Date & initial all entries



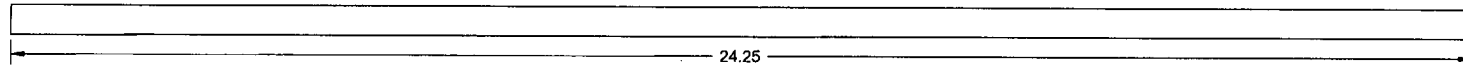
80749



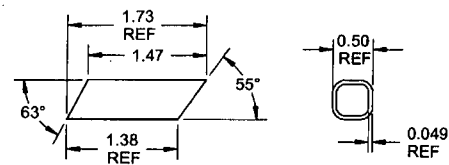
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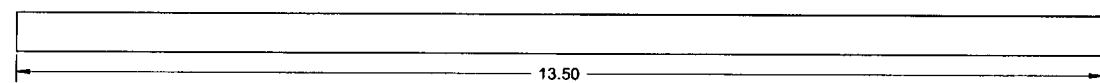
**D4277-3 RIB**



**D4277-5 RIB**



**D4277-7 RIB**



**D4277-9 RIB**

- NOTES:**
- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049  
-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

**RELEASED**  
2011-02-24  
MM

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MFG. APPR.		<b>D4277</b>	SHEET 2 OF 3
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DE APPR.		<b>RIBS</b>	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

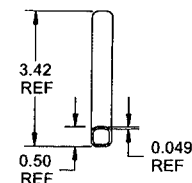
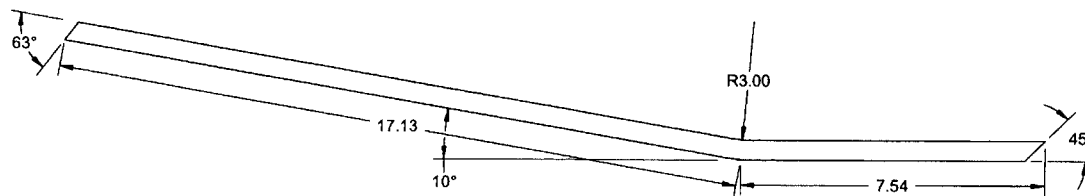
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

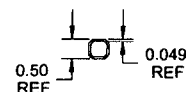
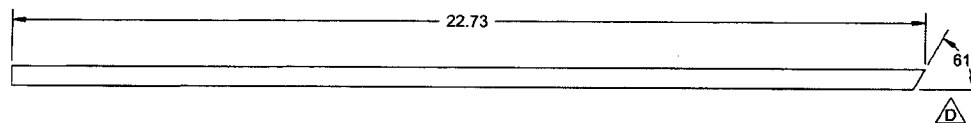
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**NOTE:** Date & initial all entries

80749



**D4277-11 RIB**



**D4277-19 RIB**

RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

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CHECKED		DRAWING NO.	REV. D
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